

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006289**Date Inspected:** 14-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI: Mr. Sun Bo

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 7

This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of OBG side plate welds SP324-001-046, SP324-001-047, SP324-001-054, SP324-001-056, SP111-001-048, SP111-001-049, SP111-001-050, SP111-001-052, SP378-001-041, SP378-001-042, SP378-001-043, SP378-001-045, SP138-001-039, SP138-001-040, SP138-001-047, SP138-001-049, SP351-001-039, SP351-001-040, P351-001-047, SP351-001-049, SP165-001-041, SP165-001-042, SP165-001-043, SP165-001-045 and Base Plate welds BP050-001-001, BP050-001-002, BP050-001-019, BP050-001-020, BP158-001-001, BP158-001-002, BP158-001-019, BP158-001-020, BP104-001-001, BP104-001-019, BP104-001-020, BP131-001-001, BP131-001-019, BP185-001-001, BP185-001-002, BP185-001-003, BP185-001-020, BP185-001-021, BP185-001-022, BP077-001-019 and BP077-001-020. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel and the welds are listed on ZPMC Notification of Witness Inspection document 001983. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027

WELDING INSPECTION REPORT

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Ultrasonic Test Report.

OBG Bay 3

This QA Inspector performed random ultrasonic (UT) inspections of approximately 10 percent length of OBG floor beam welds FB015-030-043, FB016-036-045 , FB011-022-045, FB020-007-117, FB020-007-122, FB024-006-117, FB024-006-122, FB023-007-117, FB023-007-122, FB028-008-117, FB028-008-122, FB019-007-117, FB019-007-122, FB027-008-117, FB027-008-122, FB024-007-117 and FB024-007-122. These welds had previously been ultrasonically inspected and accepted by ZPMC inspection personnel and the welds are listed on ZPMC Notification of Witness Inspection document 001986. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on this inspection see the TL6027 Ultrasonic Test Report.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
